

# Work Order ID 69994

Wednesday, May 25, 2011 10:52:20 AM



Page 1

Item ID: D4382-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Angled Bearpaw Clamp

Start Date: 5/25/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/3/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *[Signature]* Date: 11-05-25

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4382	A

100 0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

304 .080

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

B 11-5-30

(4)

110 0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

B 11-5-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 69994**

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Start Date: 5/25/2011 Start Qty: 2.00



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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00



0.00 8 ul 5/31

QC

Memo

Quality Control

(x4)

130

Form as per dwg

0.00



0.00 JB 11/6/07

Brake NC

Memo

Brake NC

(4)

140

QC5- Inspect part completeness to step on W/O

0.00



0.00 8 ul 6/07

QC

Memo

Quality Control

(x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Wednesday, May 25, 2011 10:52:20 AM



Page 3

Item ID: D4382-1

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Setup Start



Revision ID:

Stop



Item Name: Angled Bearpaw Clamp

Start Date: 5/25/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/3/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

Identify as per dwg & Stock Location: Y53

0.00



Packaging

Memo

0.00

Packaging

11/6/88 (40)

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/88  
mf  
11-06-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, May 25, 2011 10:52:26 AM

Page 1

Work Order ID: 69994

Parent Item: D4382-1

Parent Item Name: Angled Bearpaw Clamp

Start Date: 5/25/2011

Required Date: 6/3/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 11.04.11 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S14GA

Purchased

No

100

sf

27.1000

0.05513

0.116063

25



FB11-5-30

304SS sheet .080

Location

Loc Qty

Loc Code

MAT020

27.1

113295

27.1

113295

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

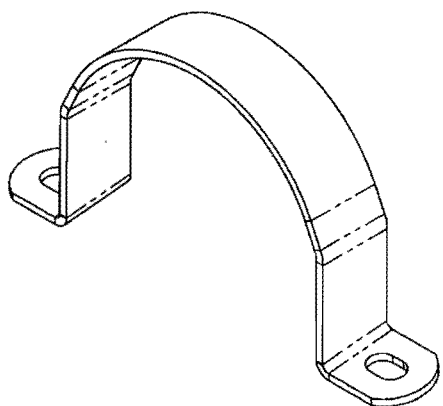
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**NOTE:** Date & initial all entries









**D4382-1 ANGLED BEARPAW CLAMP**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMEND.  
WITHOUT NOTICE  
WORK ORDER  
NO. 69994  
P11-05-25

**RELEASED**  
2011-04-21

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 14 GAUGE (0.078 THICK)  
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240  
REF. DART SPEC. M304S14GA
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4382-1" AND B/N "BXXXXX"  
PER DART QSI 044 6.1 (FINE POINT MARKER)
  - 7) WEIGHT: 0.13 lbs

A		NEW ISSUE		AJS	11.03.28
REV.		DESCRIPTION		BY	DATE
DESIGN		AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN		AJS			
CHECKED			DRAWING NO.	REV. A	
MFG. APPR.			D4382		SHEET 1 OF 2
APPROVED			TITLE		SCALE
DE APPR.			ANGLED BEARPAW CLAMP		NTS
DATE		11.03.28	COPYRIGHT © 2011 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		

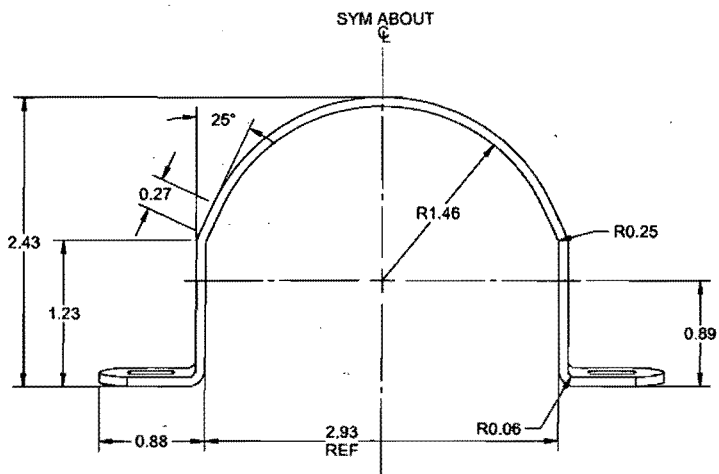
W/O:		WORK ORDER CHANGES					
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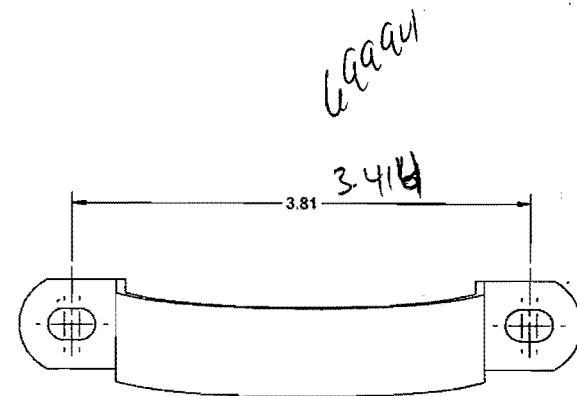
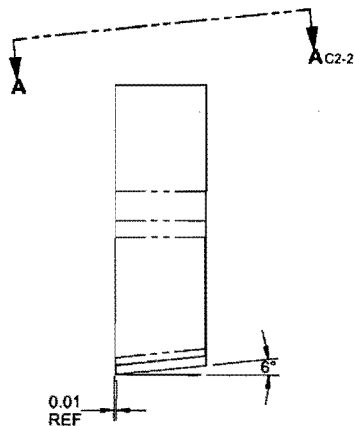
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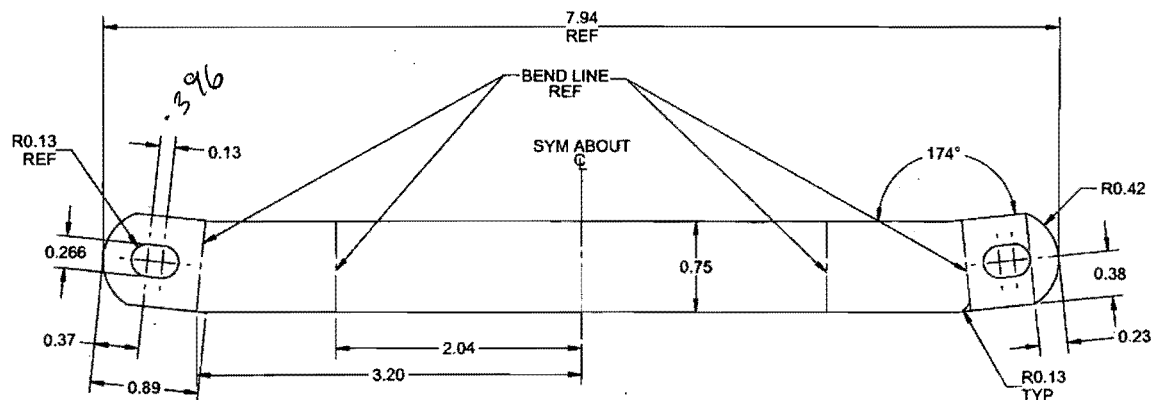
**NOTE:** Date & initial all entries



**D4382-1 ANGLED BEARPAW CLAMP**






**VIEW A-A D3-2**



**D4382-1F ANGLED BEARPAW CLAMP  
(FLAT PATTERN)**

**RELEASED**  
2011-04-26  
AM

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4382	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ANGLED BEARPAW CLAMP	NTS
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